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Work Order ID 69026 Wednesday, April 27, 2011 10:57:27 AM			Page 1
Item ID: D3201-4 Revision ID:	Accept	1 11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Setup Start
Item Name: Doubler Start Date: 4/27/2011 Start Qty: 12.00 Required Date: 5/3/2011 Req'd Qty: 12.00 Reference:		Cust Item ID: Customer:	-
Approvals: Process Plan:	Date: SPC (Y/N):	Date:	Run Start
Sequence ID/ Operation Work Center ID Description	Set Up/ Run Hours	Tool ID Tool # Plan Code	Accept Reject Reject Insp. Qty Qty Number Stamp
Draw Nbr Revision Nbr D3201 Rev B			
The second of th	<u>}</u>		1811-5-4 DG
QC2- Inspect parts off macl	·		1B11-5-4

QC8- Inspect parts - second check

120 QC

0.00 S worloy

Memo

Quality Control

	-									
W/O:				W	ORK ORDER CHANGES			- 1116		1
DATE	STEP	PRO	CEDU	RE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fa	uit Ca	tegory: NC	R: Yes	No DQ	A :	Date: _	
	Re	esolution:	Di	sposit	ion: Q <i>I</i>	A: N/C CI	osed:		Date: _	
NCR:		V	VOR	OR	DER NON-CONFORMANC	E (NCF	R)			
DATE	STEP	Description of NC		•••	Corrective Action Section B	Sign 8		cation	Approval	Approval
	O.L.	Section A		itial ef Eng	Action Description Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector
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Work	Orde	er ID	690	126

Page 2

Wednesday, April 27, 2011 10:57:27 AM

Item ID:

D3201-4

Accept



Setup Start



Stop



Revision ID: Item Name: **Start Date:**

Doubler

Required Date: 5/3/2011

4/27/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

Date:

Run

Start



QC: _____ Date: ____

Operation

Description

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Reject

Qty

Accept

. .

Qty

Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

130

Small Fab Small Fab

Small Fab

Memo

Deburr Stack

Set Up/ **Run Hours**

0.00

0.00

140

Brake NC

Brake NC

NC BRAKE

Memo

1-Bend as per Dwg D3201

0.00

SB 1165/05

150

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00 Sucstor

W/O:				WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	CEDUR	E CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fau	ılt Categ	ory:	NCF	R: Yes N	lo DQA	.:	Date:	
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NCR:			WORK	ORDE	R NON-CONFORM	ANCE	(NCR)		···		
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DATE	STEP	Section A	Init Chief	tial Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
											
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Work Order ID 69026

Page 3

Wednesday, April 27, 2011 10:57:27 AM

Item ID:

D3201-4

Setup Start

Stop

Revision ID:

Doubler Item Name:

Required Date: 5/3/2011

Start Qty: 12.00 4/27/2011

Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: _____

Tooling:

Accept

Date:

Start Run



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

160

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Stamp

Hand Finishing

Memo

0.00

170

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

180

Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00

Packaging

W/O:				WORK ORDER (CHANGES				;
DATE	STEP	PRO	CEDURE	CHANGE	1	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	Initia	Corrective Actio Action Des		Sign &	Verification	Approval	Approval
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Work Order ID 69026



Page 4

Wednesday, April 27, 2011 10:57:27 AM

Item ID:

D3201-4

Setup Start

Revision ID:

Start Date:

Item Name:

Required Date: 5/3/2011

Doubler

4/27/2011

QC:_

Start Qty: 12.00

Req'd Qty: 12.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

QC21- Final Inspection - Work Order Release

Tooling:

0.00

Accept

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start

Stop



Stop

Sequence ID/

Work Center ID

190

Quality Control

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Run

Reject Number

Insp. Stamp

0.00 Memo

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W/O:				WO	RK ORDER CHANG	ES					,
DATE	STEP	PRO	CEDUR	E CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fau	It Categ	ory:	_ NCR	: Yes 1	No DQ	A:	Date: _	
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NCR:		\	WORK	ORDE	R NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	Description of NC			Corrective Action Section	ion B	0: 0	Verifi	cation	Approval	Approval
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Picklist Print

Wednesday, April 27, 2011 10:57:34 AM

Work Order ID: 69026

Parent Item:

D3201-4

Parent Item Name: Doubler



Start Date: 4/27/2011

Required Date: 5/3/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev: A

Removed from 9 Digit Now on Waterjet

06-01-25

JLM 06-08-14 JLM

EC

' IPP Rev:B IPP Rev :C

Added scribing, NCR262 07.11.29 IPP Rev:D

10.10.29 remove scribe b# & p# DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	18.6488	0.045	0.568421	(.		
] [] [] [] []	18	11-5-4		

2024-T3 .050 sheet

Location MAT22

Loc Qty

Loc Code

114968

18.648842 18.648842

114968



W/O:			W	ORK ORDER CHAN	GES			,
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·						
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C Cld	osed:	Date: _	
NCR:		1	WORK OR	DER NON-CONFORM	ANCE (NCR)		·
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	ection B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Orner Ling	Office Eng	Date			
	·							
	,							
							·	
						1		

DART AEROSPACE LTD	Work Order:	49024
Description: Doubler	Part Number:	D3201-4
Inspection Dwg: D3201 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.76	+/-0.030	3,757	*		V 1802	
3.46	+/-0.030	3.456	>		V	
1.68	+/-0.030	1.686	>		ν	
0.050	+/-0.010	.oC3	>		ν	
	·					

Meas	ured by:	NB	Audited by:	Preliminary	Approval:	,
	Date:	11-5-4	Date: 11 coloy		Date:	
Rev	Date	Change			Revised by	Approved
Α	03.11.28	New Issue			KJ/RF A	<u> </u>
R	10 10 27	EAL sheet cre	eated for each part for D3201-	3/-4	KJ 98	1 /24

Da	art	Ae	ros	pace	Ltd
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W/O:			W	ORK ORDER CHA	NGES						
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		•		NCR: Yes No DQA: Date:							
	R	esolution:	Dispositi	on:	QA: N/C Closed: Date:						
NCR:			WORK ORE	DER NON-CONFO	RMANC	E (NCF	R) .				
DATE	STEP	Description of NC Section A	Corrective Action		Section B			cation	Approval	Approval	
			Initial Chief Eng	Action Descript Chief Eng	lon	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector	
							,				
							•				
					1						





R0.50

(2 PLACES)

3.57

R_{0.12}

0.58

8.00

R_{0.25}

(3 PLACES)

	DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHECK	ŒD,	APPROVED//	DRAWING NO. REV. B
		4	#	D3201 SHEET 1 OF 1
ı	DATE	***************************************	<u></u>	TITLE SCALE
	03.1	1.03		DOUBLER 1:2
	Α		03.08.07	NEW ISSUE
	В		03.11.03	MODIFY D3201-1, ADD D3201-3/-4

03.1114

2.95 -

SHOP COPY

RETURN TO

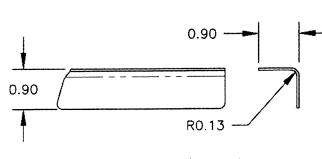
ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12
(TYP)

GRAIN
DIRECTION

D3201-3/-4 ANGLE
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 4.89 -

<u>D3201-1 DOUBLER</u> 0.040 THICK

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)

(REF. DART SPEC M2024T3S)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			W	ORK ORDER CHA	NGES							
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cate	NC	R: Yes	Date:						
	R	esolution:	olution: Disposition:				QA: N/C Closed: Da					
NCR:			ORK ORD	ER NON-CONFO	RMANC	E (NCR	(1)					
DATE	STEP	Description of NC Section A	Corrective Action		Section B			cation	Approval	Approval		
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE